 EM DIVISION	QUALITY PLAN		DOC NO	323-QP-CF-190
	QUALITY PLAN FOR CASTING - SUPPLIERS		ISSUE NO	1
			PAGE NO	1 OF 2

1 Purpose

To establish procedures of inspection and testing of castings at supplier end.

2 Scope

Covers inspection and testing of following casting :

Table-1

SI NO	CastingNo	Description	Material	Scope of Supply
1	116TF31968	PLATE GUIDE CASTING	C1103-99 Gr. 23-45 of IS:1030	Normalised to 130-170 BHN

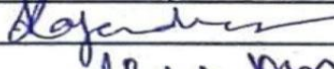

Responsibility


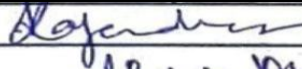

(1)The section head of Castings/Forgings Materials group to ensure that the quality plan is sent to all suppliers along with the purchase order.

(2)The suppliers shall ensure that quality plan is followed for testing and inspection of the Castings.

Procedure

The quality plan is applicable for castings. Supplier should carry out inspection and testing of castings as per Table -2

	Name	Signature	Date
Prepared by	RAJENDRA BABU K		09.11.2020
Approved by	MAHESH KULKARNI		09.11.2020

 EM DIVISION	QUALITY PLAN		DOC NO	323-QP-CF-190
	QUALITY PLAN FOR CASTING - SUPPLIERS		ISSUE NO	1
			PAGE NO	2 OF 2
Table - 2				
SLNO	TEST	PERIODICITY OF TESTS		
1	Visual inspection	The Castings shall be free from foundry defects such as: shrinkage, porosity and blow holes, hot tear and cracks, hard spots, sand fusion etc. and other surface abnormalities, shall be checked on 100% of castings.		
2	Dimensions	For one number sample casting and audit check, dimensions shall be checked by layout method and lines drawn should be visible with punch marks. Dimensional check sheet should contain all dimension with baloon number in drawing with weight details. Rectangle box area 195x280mm should be checked using template. Untoleranced dimensions shall be as per IS4897-1994. Audit check to be done for every 10th number of casting for dimensional repeatability, check as per above check list.		
3	Composition	1 No sample /heat shall be checked and test report shall be sent along with every consignment.		
4	Heat Treatment	Hardness report along with temperature charts shall be sent along with each supply.		
5	Mechanical Properties	One no. test bar per heat to be checked for mechanical properties and report to be sent along with each consignment		
6	NDT	<u>MPI</u> : 100% castings shall be checked after shot blasting on all surfaces to ensure freedom from cracks and hot tears. <u>UT</u> : To carryout on all supplies across all accessible area. <u>RT</u> : shall be done at sample stage to prove methoding and ensure defect free casting. Acceptance Level II ASTM E 446.		
7	Idenification / Traceability	The Castings shall be marked with vendor code, Part no. & SI no(if applicable), heat no(if applicable) & BEML logo as per DS1019C		
8	Supply Condition	Sample castings identified with white paint to be submitted for approval prior to the bulk supply& regular supplies to be as per PR1029C.		
		Name	Signature	Date
Prepared by		RAJENDRA BABU K		09.11.2020
Approved by		MAHESH KULKARNI		09.11.2020